

Work Order ID 134072

Wednesday, March 29, 2017 1:21:45 PM

134072

Page 1

Item ID: D3516-041

Revision ID:

Item Name: Basket Base Assembly (A119)

Start Date: 6/26/2015 Start Qty: 1.00

Required Date: 6/29/2015 Req'd Qty: 1.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3516

Rev C

100

100

Small Fab

Small Fab

Small Fab

Memo

1-Cut rib D3516-1 as per dwg D35162-Cut rib D3516-3 as per dwg D35163-
Cut rib D3516-5 as per dwg D35164-Cut rib D3516-7 as per dwg D35165-
Cut rib D3516-15 as per dwg D35166-Cut rib D3516-9 from D3166-1 (4)
using DT8365 jig

0.00

0.00

PTO

110

110

Large Fab

Large Fab

Large Fab

Memo

Weld assembly as per dwg D3516

0.00

0.00

120

120

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐			
Date : <u>17-03-29</u>	Step #: <u>110</u>	QTY Effective : <u>①</u>		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		<u>PD 17-03-29</u> Completed By <u>CPC 17-3-29</u> Lead hand / Supervisor Approval Verification <u>PD 17-03-29</u> QC / QA Coordinator Approval <u>PD 17-03-29</u>	
Basket frame was built for testing by eng.		basket no good for production scrap + destroy.			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☒ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☒ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

134072

Wednesday, March 29, 2017 1:21:45 PM

N900040100

Setup Start *NS1*

Stop ***NS2***

1

Start Date: 6/26/2015 **Start Qty:** 1.00

Required Date: 6/29/2015 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

140

0.00

140

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut expanded metal for base as per dwg D3516 2-Cut expanded metal for base ends as per dwg D35163-Weld expanded metal to base as per dwg D3516

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

Work Order ID 134072

Wednesday, March 29, 2017 1:21:45 PM

134072

Page 3

Item ID: D3516-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Base Assembly (A119)
Start Date: 6/26/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/29/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				_____	_____	_____	_____
170 *170* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1ST COAT:START TIME: _____OVEN TEMPERATURE: _____FINISH TIME: _____ ***** 2nd coat if necessary*****2ND COAT:START TIME: _____ OVEN TEMPERATURE: _____	0.00 0.00				_____	_____	_____	_____
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				_____	_____	_____	_____

Work Order ID 134072

Wednesday, March 29, 2017 1:21:45 PM

134072

Page 4

Item ID: D3516-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Base Assembly (A119)
Start Date: 6/26/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/29/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

W170329

Picklist Print

Wednesday, March 29, 2017 1:21:44 PM

Page 1

Work Order ID: 134072

134072

Parent Item: D3516-041

D3516-041

Parent Item Name: Basket Base Assembly (A119)

Start Date: 6/26/2015

Required Date: 6/29/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev. A 06.05.31 Preliminary EC
IPP rev. b 06.07.27 updated EC
IPP Rev:C 08-02-25 ECN 1138P DD verified by: LL
IPP Rev:D 08-03-18 ecn 1136 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2232-3		Manufactured	No			100	Each	28.0000	2	2			
D2232-3									**				
Basket Hinge													
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				28					
				156858				11					
				157388				12					
				158439				5					
D2327-3		Manufactured	No			100	Each	55.0000	2	2			
D2327-3									**				
Spacer Bushing													
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				55					
				148585				5					
				154190				50					
D2581		Manufactured	No			100	Each	56.0000	2	2			
D2581									**				
Mounting Bracket													
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				56					
				152803				44					
				156869				12					

Picklist Print

Wednesday, March 29, 2017 1:21:44 PM

Page 2

Work Order ID: 134072

134072

Parent Item: D3516-041

D3516-041

Parent Item Name: Basket Base Assembly (A119)

Start Date: 6/26/2015

Required Date: 6/29/2015

Start Qty: 1.00

Required Qty: 1.00

D3166-1 Manufactured No 100 Each 4.0000 4 4

D3166-1

Basket Hoop

Location

Loc Qty

Loc Code

WA004

4

157365

4

D3442-1 Manufactured No 100 Each 25.0000 2 2

D3442-1

Shim

Location

Loc Qty

Loc Code

WA004

25

142837

11

157354

14

D3516-11 Manufactured No 100 Each 3.0000 6 6

D3516-11

Clevis

Location

Loc Qty

Loc Code

Mezz

2

137499

2

WA004

1

130941

1

D3516-13 Manufactured No 100 Each 51.0000 4 4

D3516-13

Clevis

Location

Loc Qty

Loc Code

Mezz

14

45564

37

45565

14

Wednesday, March 29, 2017 1:21:44 PM

Shop Packet Print

Page 2

Picklist Print

Wednesday, March 29, 2017 1:21:44 PM

Page 3

Work Order ID: 134072

134072

Parent Item: D3516-041

D3516-041

Parent Item Name: Basket Base Assembly (A119)

Start Date: 6/26/2015

Required Date: 6/29/2015

Start Qty: 1.00

Required Qty: 1.00

D3725-1	Manufactured	No	100	Each	2.0000	2	2
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D3725-1

Hoop

Location

Loc Qty

Loc Code

WA004

2

157065

2

M304EX0.75-16F

Purchased

No

100

sf

156.5000

60

60

M304FX0 75-16F

Expanded Metal Flat SS

Location

Loc Qty

Loc Code

WA004

156.5

M136991

156.5

M304TS0.750W.065

Purchased

No

140

f

793.8049

50.65

54

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

WA004

793.804944

m133412

2.264944

m136378

93.54

m136907

47

m137065

651

Work Order Summary

Wednesday, March 29, 2017 1:19:59 PM

Page 1 of 2

Criteria : Work Order ID: 134072 Item ID: D3516-041 Product Family LARGE FAB
 Work Order Start Dates 6/26/2015 to 6/26/2015 11:59:59 PM Work Order Required Dates 6/29/2015 to 6/29/2015 11:59:59 PM
 All References
 Work Order Status Released

Work Order ID	134072	Required Qty	1.0000	Status Code	Released
Item ID	D3516-041	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Basket Base Assembly (A119)				
Current Acct Value	\$3,267.489				
Start Date	6/26/2015	Required Date	6/29/2015	Completed Date	
Standard	** Actual **	** Acct. Value **	** Variance **	** Variance % **	
Direct Costs	Total	Each	Each	Each	Each
Material	\$140.916	\$0.000	\$506.507	\$506.507	100.00%
Labor	\$319.242	\$0.000	\$861.464	\$861.464	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$756.809	\$0.000	\$2,165.561	\$2,165.561	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$1,216.967	\$0.000	\$3,533.532	\$3,533.532	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
D2327-3 Spacer Bushing	2.0000		6/30/2015	2.0000	\$21.086
D3166-1 Basket Hoop	4.0000		6/30/2015	4.0000	\$164.241
D3516-11 Clevis	6.0000		6/30/2015	6.0000	\$93.947
D3516-13 Clevis	4.0000		6/30/2015	4.0000	\$20.486
D3725-1 Hoop	2.0000		6/30/2015	2.0000	\$174.374
M304TS0.750W.065 304 SQ Tube .75x.75x.065W	54.0000		6/30/2015	54.0000	\$78.862
Total Matl Amts:					\$552.996

Work Center Large Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
lavi01												
6/29/2015												
110			0.00	0.00	0.92	0.92	1.00	\$0.000	\$20.543	\$49.309	\$0.000	\$69.852

Wednesday, March 29, 2017 1:19:59 PM

Work Order Summary

Page 1 of 2

6/30/2015											
110		0.00	0.00	3.01	3.01	1.00	\$0.000	\$67.073	\$160.993	\$0.000	\$228.066
110		0.00	0.00	0.82	0.82	1.00	\$0.000	\$18.183	\$43.643	\$0.000	\$61.826
Total:		0.00	0.00	4.74	4.74	3.00	\$0.000	\$105.798	\$253.945	\$0.000	\$359.743

Work Center Small Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
CRUI01												
6/29/2015												
100			0.00	0.00	0.66	0.66	1.00	\$0.000	\$13.860	\$32.487	\$0.000	\$46.347
lavi01												
6/26/2015												
100			0.00	0.00	1.09	1.09	1.00	\$0.000	\$22.960	\$53.817	\$0.000	\$76.778
6/29/2015												
100			0.00	0.00	2.57	2.57	1.00	\$0.000	\$54.159	\$126.944	\$0.000	\$181.103
Total:			0.00	0.00	4.32	4.32	3.00	\$0.000	\$90.979	\$213.249	\$0.000	\$304.228